

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028085**Date Inspected:** 03-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG

This QA observed the following welders working in OBG 12W at various locations:

Weld 12W W2.1-A1 (4G, CJP):

Authorized welder Jin Pei Wang #7299 was observed continuing on from the previous day with welding on the deck plating underside at Y location 7500 and 3700, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-3110-4.

Weld 12W PP111.1-LS1 (3G, CJP):

Authorized welder Mike Jimenez #4671 was observed continuing on from the previous day with welding on the deck longitudinal stiffener utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1032-3.

Welds 12W W2.1 PP116-BW2 (3G, CJP) & 12W W2.1 PP116-BW3 (3G, CJP):

Authorized welder Chris Bruce #8901 was observed welding on the panel point web complete joint penetration weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 &

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ABF-WPS-D15-1040A.

Welds 12W W2.1 PP117-BW2 (3G, CJP) & 12W W2.1 PP117-BW1 (3G, CJP):

Authorized welder Chang Giu Chan #2312 was observed welding on the panel point web complete joint penetration weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A & ABF-WPS-D15-1030.

Weld 12W 13W-B1 (3G, CJP):

Authorized welder Jin Quan Huang #1088 was observed welding the weld back gouge progressing upward utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1110 Rev.1.

This QA randomly observed OBG 12W QC Inspector Chris Conche, verifying fit up of various welds, Magnetic Particle Inspection (MT) the back gouges and verifying WPS compliance of welders throughout the day. Also observed were AB/F JV personnel removing lifting padeyes from Panel Point 116 on the external side of the deck plating at OBG 12W.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

Weld 12W W2.1-A1:

- Indication removal verification at Y=3850 face B. (35 x 30 x 16mm deep. 100%, MT Accept.)

Weld 12W 13W-B1:

- Indication removal verification at Y=0 face B. (40 x 40 x 10mm deep. 100%, MT Accept.)

Weld 12W PP111.1-LS1:

- 230mm of weld back gouge. (100%, MT Accept. Face B)

Weld 12W W2.1 116.5-BW2 (1 of 2 - Upper Section):

- 260mm of weld back gouge. (100%, MT Accept. Face B)

Weld 12W W2.1 117-BW2:

- 390mm of weld back gouge. (100%, MT Accept. Face B)

The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



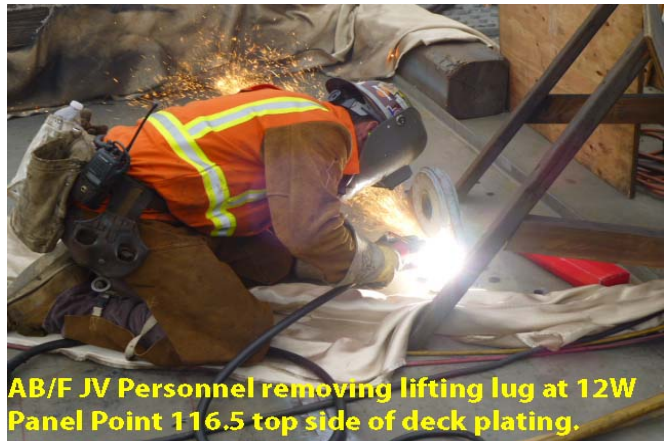
12W W2.1 PP116-BW2
Welder Bruce Chris #2312 welding 3G at Panel Point 116 Web.



12W 13W-B1
Welder Jin Quan Huang #1088 starting weld for B plate with ABF-WPS-D15-1110A Rev.1.



12W W2.1-A1
Welder Jin Pei Wang #7299 welding 4G at Y location 3700.



AB/F JV Personnel removing lifting lug at 12W Panel Point 116.5 top side of deck plating.

Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy - (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer